

Work Order ID 70144



Page 1

Monday, May 30, 2011 10:52:42 AM

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 5/30/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 5-30

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580-041

Rev.D DEO-D1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041

CHG004

CHG002

8/11/07/04

for BG 11-6-30

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend I

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

[Handwritten signature]

11-6-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
Skidtubes	Memo	0.00							
Skidtubes	1- Deburr ends and remove bending marks								
	2- Prepare tube for swaging as per QSI 002								
130	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

31/06/17

1 0 BE 11/06/20

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI004
A/R ☐ ☐ Aluminum Rod

M117456

BE 11/06/20

2-Grind welds on step as per Dwg D2580

DL 11/06/21

3-Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002
and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x 17G to start
expansion and finish with 1/2 x 18G to achieve dwg dimension.

WELDED A/R M117456

BE 11/06/20

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Debur

3 DL 11/06/21

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

BE 11/06/21

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

150



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

DL 11/06/21

@

W/O:		WORK ORDER CHANGES					
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Reference:

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Sul06/21



Memo

0.00

170



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

0.00

IX Ø M-11/06/22

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:20
320 OF
1:50

IX Ø M-11/06/23

M116964

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 11/06/27

W/O:		WORK ORDER CHANGES					
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Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200		0.00							
	HandFinish								

Hand Finishing

Memo

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
 A/R ☐ ☐ ☐ Sikaflex-291 ☐ M117516
 Sikaflex expire date: 15/01

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
 A/R ☐ ☐ ☐ Sikaflex-291 ☐ M117516
 Sikaflex expire date: 15/01

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
 Batch: M117863

1 0 1106127

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8 w/06/07



Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

Packaging

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041

Location: _____
PPP Rev: *L*

11/7/48

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/54
ME
11-07-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube




Start Date: 5/30/2011

Required Date: 6/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
KJ IPP Rev P 10.02.19
per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																																																																																				
D4202-1  Spacer	D2579	Manufactured	No			140	Each	443.0000	20	20		BE 11/06/20 B70761 20																																																																																					
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67308	1																																																																																																
67430	140																																																																																																
D2580-1  205 Skidtube bent detail		Manufactured	No			110	Each	4.0000	1	1																																																																																							
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D2576-3  Step (maching detail)		Manufactured	No			140	Each	54.0000	1	1		BE 11/06/20																																																																																					
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66156	54																																																																																																

BE 11/06/20
B70761 20

DP 11-6-15

BE 11/06/20

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Page 2

Work Order ID: 70144

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 5/30/2011

Required Date: 6/15/2011

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200 Each

53.0000

1

1



Cap



u106127

Location

Loc Qty

Loc Code

FP007

53

53791

16

65519

2

65569

35

x1

AN3-5A

Purchased

No

200 Each

1,156.000

2

2



Bolt



u106127

Location

Loc Qty

Loc Code

ST350

1156

115371

356

117423

800

x2

AN960JD10L

NAS1149D0332J

Purchased

No

200 Each

0.0000

2

2



Washer

M117291



(x2) u106127

ALS7-1032-130

Purchased

No

200 Each

1,983.000

50

50



Insert



u106127

Location

Loc Qty

Loc Code

ST281

16

117331

16

ST282

1967

116800

7

117717

1960

x50

W/O:		WORK ORDER CHANGES					
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Start Date: 5/30/2011

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Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 200 Each 2,361.000 50 50
BOLT

Location

Loc Qty

Loc Code

ST350

2361

117094

955

117313

106

117688

800

117795

500

M118112

x50

AN960C10L NAS1149C0332 Purchased No

200 Each 0.0000 50 50



washer

M118078

(x50) M118078

D3566-13 Manufactured No

200 Each 44.0000 1 1



Gasket

M118078

Location

Loc Qty

Loc Code

FP

26

69281

26

FP014

18

68344

18

D3566-5 Manufactured No

200 Each 35.0000 1 1



Gasket

M118078

Location

Loc Qty

Loc Code

FP015

35

67589

2

68961

33

x1

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Shop Packet Print

Page 3

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Start Qty: 1.00

Required Qty: 1.00

D3566-1

Manufactured No

200 Each

49.0000

2 2



Gasket



JL 11/06/27

LocationLoc QtyLoc Code

FP015

49

68924

25

69279

24

D3564-11

Manufactured No

200 Each

12.0000

1 1



Wearshoe



JL 11/06/27

LocationLoc QtyLoc Code

FP019

12

69119

12

D3564-13

Manufactured No

200 Each

30.0000

1 1



Wearshoe



JL 11/06/27

LocationLoc QtyLoc Code

FP016

18

69280

18

FP017

12

66805

12

D3564-9

Manufactured No

200 Each

15.0000

1 1



Wearshoe



JL 11/06/27

LocationLoc QtyLoc Code

FP019

15

67590

4

68349

11

Xi

Monday, May 30, 2011 10:52:50 AM

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Start Date: 5/30/2011

Required Date: 6/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

200 Each

21.0000 1 1



Wearshoe



21 11/06/27

Location

Loc Qty

Loc Code

FG

2

34806

2

FP019

19

68960

19

D2594-3

Manufactured No

200 Each

980.0000 16 16



O-Ring, 205 Skidtube



21 11/06/27

Location

Loc Qty

Loc Code

FP-A

980

65518

54

66952

926

D2594-1

Manufactured No

200 Each

425.0000 16 16



Plug, 205 Skidtube



21 11/06/27

Location

Loc Qty

Loc Code

FP-A

425

42807

28

66932

106

67441

7

68943

284

21 11/06/27

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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 *[Signature]***DEO ATTACHED**

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70144

[Signature] 11-05-30

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

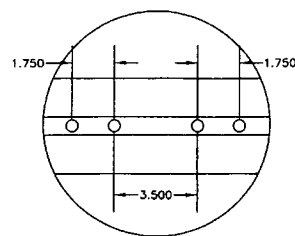
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

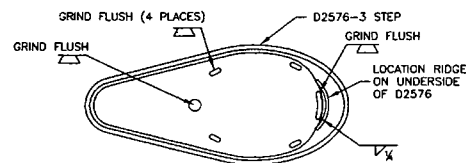
NOTE: Date & initial all entries

u/o 70144

DETAIL E
SCALE 5:24



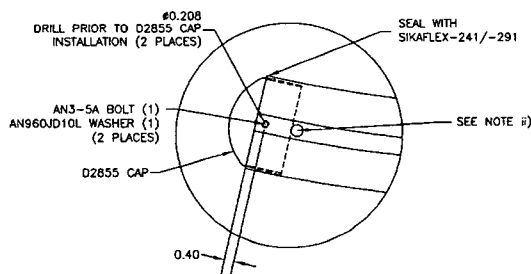
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SCALE 5:24



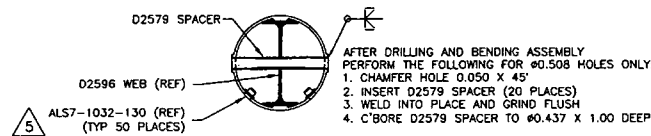
RELEASED
07.06.18

DEO ATTACHED

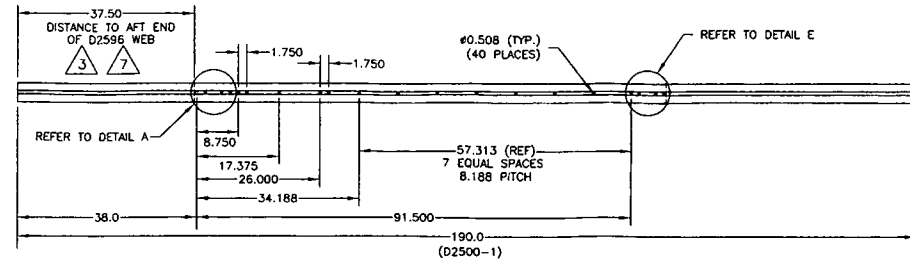
DETAIL G
SCALE 5:24



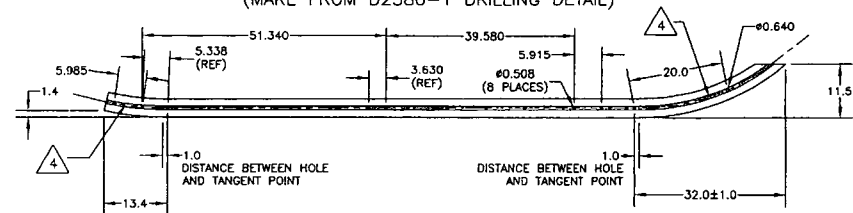
SECTION H-H
SCALE 5:24



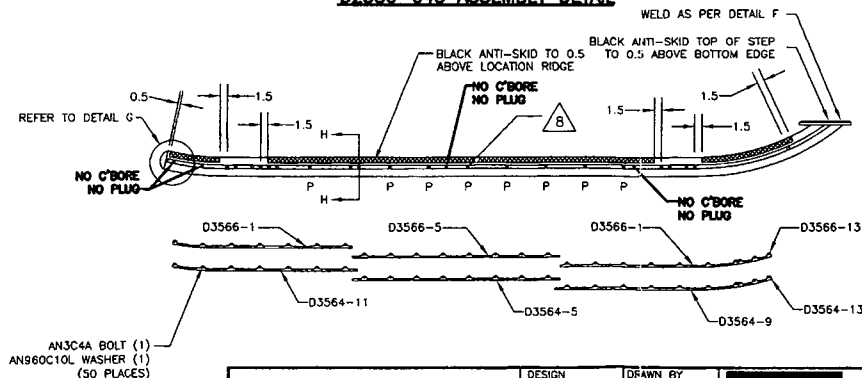
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



D2580-045 NOTES

- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA	REV. 0
CHECKED <i>TH</i>	APPROVED <i>TH</i>	DRAWING NO. D2580	SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D2580	TITLE 205 SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2580-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>L</i>	MFG. APPR. <i>B</i>	APPROVED <i>MP</i>		DE APPR. <i>#</i>		
DATE 10.09.22	DATE 10.11.04	DATE 10.11.04	DATE 10/11/04		DATE 10.11.04		

PURPOSE:

CHANGE ALL WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

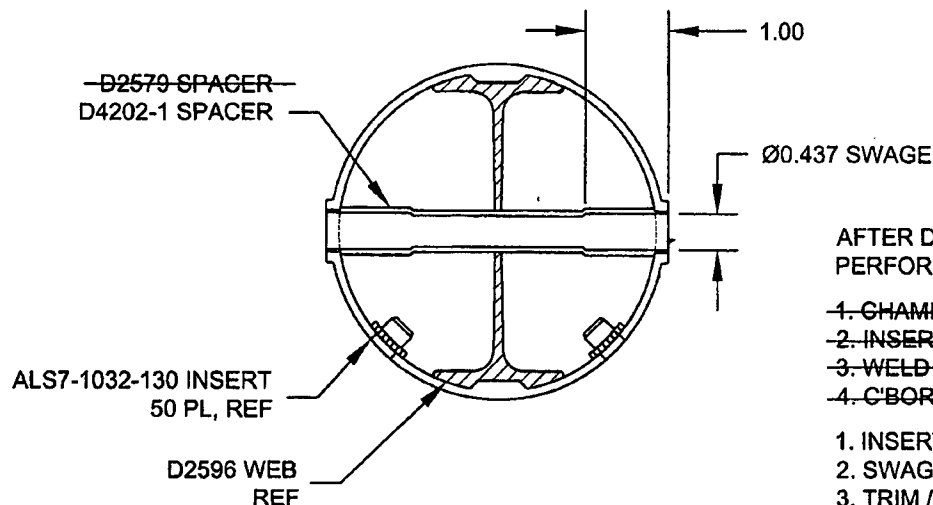
WAS

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-045		
20	24	D2579	CROSS BOLT SPACER

IS

20	24	D4202-1	SPACER
----	----	---------	--------

SECTION D-D & SECTION H-H ARE AMENDED AS FOLLOWS:



SECTION D-D
NOT TO SCALE

SECTION H-H
NOT TO SCALE

RELEASED
2010-11-18
MP

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.060 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

1. INSERT D4202-1 SPACER, 20 PL (-041) OR 24 PL (-045)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Linda Lacelle

From: dshepherd@dartaero.com
Sent: April 18, 2011 11:36 AM
To: Linda Lacelle; Mike Petsche
Cc: Bill Beckett; 'Chris Provencal'; 'Eric Charbonneau'
Subject: Re: Alum. Solution Anneal - swaging

Makes sense to me ... We don't want to get caught short ... Make sure that if we do this, they are identified w the old CHG number.

David

Sent from my BlackBerry device on the Rogers Wireless Network

From: "Linda Lacelle" <llacelle@dartaero.com>
Date: Mon, 18 Apr 2011 11:21:10 -0400
To: 'Mike Petsche' <mpetsche@dartaero.com>; <dshepherd@dartaero.com>
Cc: 'Bill Beckett' <bbeckett@dartaero.com>; 'Chris Provencal' <cprovencal@dartaero.com>; 'Eric Charbonneau' <echarbonneau@dartaero.com>
Subject: RE: Alum. Solution Anneal - swaging

I am ready to weld some up, I don't want to get into trouble with L/T's on these, any objections??
LL

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: April 18, 2011 10:42 AM
To: 'Linda Lacelle'; dshepherd@dartaero.com
Cc: 'Bill Beckett'; 'Chris Provencal'; 'Eric Charbonneau'
Subject: RE: Alum. Solution Anneal - swaging

Well I'm not sure what to say.

CC7
CHG ~~CHG~~ D2579

It is my understanding that the swaging will still make sense even with the extra hoops we need to jump through.

If there is still uncertainty on the delivery of the material, we CAN still weld them if we need to.

And while this might be less than "world class", couldn't we take some of our tubing that we have in stock and zap it with the welder to knock down the temper a little? Ground clamp on one end, torch on the other.....BZZZZZZT.

(I'm only sort of joking....because I bet it would work)

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: April 18, 2011 9:44 AM
To: dshepherd@dartaero.com; 'Mike Petsche'
Cc: Bill Beckett; Chris Provencal; Eric Charbonneau
Subject: RE: Alum. Solution Anneal - swaging
Importance: High

NO. 251

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 68708-68708
Part number: 205-634-041
Description: 205
Welding Process: Tig[] Mig[]
Base material: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[] fail[]
Penetration: pass[] fail[]

UNACCEPTABLE

Cracks: pass[] fail[]
Undercut: pass[] fail[]
Pin holes: pass[] fail[]
Overlap (cold lap): pass[] fail[]
Porosity (surface): pass[] fail[]
Coloration: pass[] fail[]

Qualifier Rat Evers Date of Test Coupon 11-05-05

Welder Barclay Elliott Date of Test Coupon 11-05-05

The above named individual is qualified in accordance with AWS D17.1.2001 to weld